

Work Order ID 160840

Thursday, May 04, 2017 2:54:21 PM

160840

Page 1

Item ID: D412-594-303

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gross Weight Towing

Start Date: 5/4/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/16/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Approvals: Process Plan: **DAS**
21 Date: **MAY 04 2017**

Tooling:

Date:

Run Start

NR1QC: **9-89**

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9705	A
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MAY 04 2017

100

Document Control

MAY 04 2017***100***

DOCUMENT CONTROL

0.00

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI9705-011 CHG001

DAS
27
9-89**MAY 14 2017**

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3
DAS
27
9-89**MAY 04 2017**

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89**MAY 14 2017**

Work Order ID 160840

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Page 2

Item ID: D412-594-303 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gross Weight Towing
Start Date: 5/4/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 5/16/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9705-011 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

3 DAS 27 9-89
MAY 04 2017
MAY 14 2017
MAY 04 2017

Picklist Print

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Page 1

Work Order ID: 160840

160840

Parent Item: D412-594-303

D412-594-303

Parent Item Name: Gross Weight Towing

Start Date: 5/4/2017

Required Date: 5/16/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 14.10.14 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5143-1 *D5143-1* Lug		Manufactured	No			110	Each	6.0000	2	6	DAS 8 9-89	MAY 04 2017	SP
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST519			6			6			
				128070			6						
AN5-46A *AN5-46A* Bolt		Purchased	No			110	Each	12.0000	2	6	DAS 8 9-89	MAY 04 2017	SP
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				Mezz			12						
				2609			12						
AN5-50A *AN5-50A* Bolt		Purchased	No			110	Each	10.0000	2	6	DAS 8 9-89	MAY 04 2017	SP
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST335			10						
				M130186			10						
NAS1149D0563J *NAS1149D0563.J* Washer		Purchased	No			110	Each	971.0000	8	24	DAS 8 9-89	MAY 04 2017	SP
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			110						
				m135774			110						
				ST263			861						
				m136295			7						
				m136986			54						
				m137361			800						

Picklist Print

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Page 2

Work Order ID: 160840

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Parent Item: D412-594-303

D412-594-303

Parent Item Name: Gross Weight Towing

Start Date: 5/4/2017

Required Date: 5/16/2017

Start Qty: 3.00

Required Qty: 3.00

MS21042L5

Purchased

No

110

Each

283.0000

4

12

MS21042L5

Nut

DAS
27
9-89

[Signature]

MAY 11 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

16

m127813

16

ST303

267

m136986

1

m137075

75

m137164

41

m137361

150

12

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 REV E
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 REV 4
REF. TCCA STC: SH03-6
REF. FAA STC: SR01742NY
REF. EASA STC: 10016828

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-594-303 MAY BE INSTALLED IN CONJUNCTION WITH D412-596-203 CROSSTUBES INSTALLED ON 412 AIRCRAFT WITH EXTENDED HEIGHT LANDING GEAR. THIS IS TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212/214/UH-1 AIRCRAFT EQUIPPED WITH DART EXTENDED HEIGHT LANDING GEAR IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D5143-1 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -303	PART	DESCRIPTION
X	D412-594-303	GROSS WEIGHT TOWING KIT
2	D5143-1	LUG
2	AN5-46A	BOLT
2	AN5-50A	BOLT
8	NAS1149D0563J	WASHER (AN960JD516)
4	MS21042L5	NUT

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-594-303	3.2 lbs	163.0 in	521.8 in-lb
	1.46 kg	4.14 m	6.0 m kg

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160840 JCS
1205-04

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	14.09.04
CERT. NO.:	SH03-6
ISSUE NO.:	4

A	NEW ISSUE	DB	14.09.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9705 REV. A SHEET 1 OF 2 TITLE 412 GROSS WEIGHT TOWING KIT SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	14.09.04		

4.0 INSTALLATION:

- 4.1 REMOVE AN5-43A BOLTS (2), AN5-45A BOLTS (2), NAS1149D0563J WASHERS (8) AND MS21042L5 NUTS (4) FROM THE AFT SADDLES. DISCARD THE FASTENERS.
- 4.2 INSTALL D5143-1 LUGS USING AN5-46A/50A BOLTS, NAS1149D0563J WASHERS AND MS21042L5 NUTS AS SHOWN IN FIGURE 1.
- 4.3 TORQUE BOLTS TO 60-85 IN-LBS (6.8-9.6 NM).
- 4.4 IT IS ACCEPTABLE TO REPLACE THE AN5-46A/50A BOLTS WITH LONGER OR SHORTER AN5 BOLTS AS REQUIRED AND/OR TO INSTALL EXTRA NAS1149D0563J WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

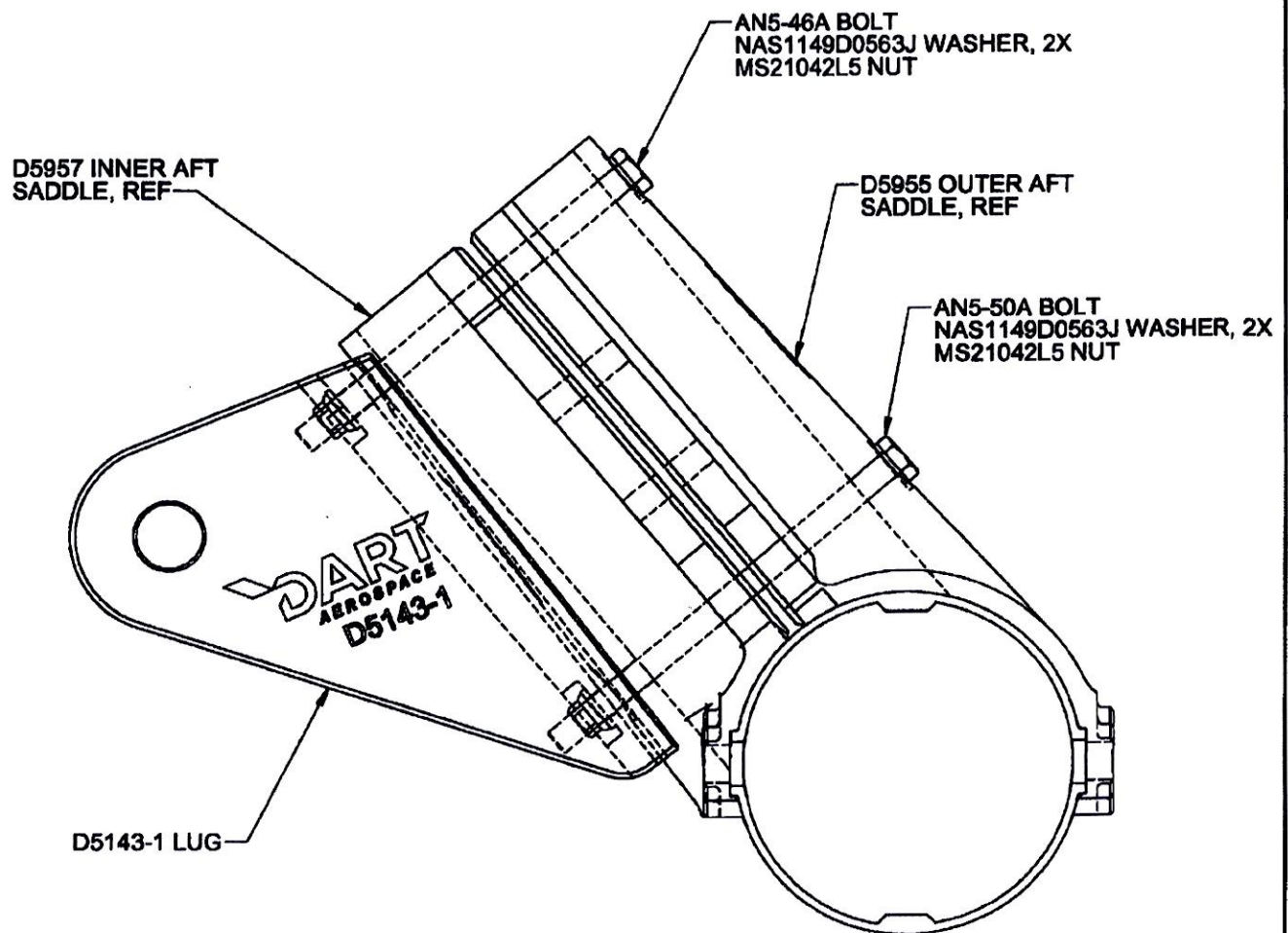


FIGURE 1: D412-594-303 GROSS WEIGHT TOWING KIT INSTALLATION
(TYPICAL AFT SADDLE)

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9705	SHEET 2 OF 2
APPROVED		TITLE	412 GROSS WEIGHT TOWING KIT
DE APPR.			SCALE NTS
DATE	14.09.04	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 REV E
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 REV 4
REF. TCCA STC: SH03-6
REF. FAA STC: SR01742NY
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	1.46 kg	4.14 m	6.0 m kg

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 14.09.04
CERT. NO.: SH03-6
ISSUE NO.: 4

A	NEW ISSUE	DB	14.09.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9705	SHEET 1 OF 2
APPROVED		TITLE	412 GROSS WEIGHT TOWING KIT
DE APPR.		SCALE	NTS
DATE	14.09.04	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Page 1

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gross Weight Towing

Start Date: 5/4/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/16/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Approvals: Process Plan: DAK 21 Date: MAY 06 2017

Tooling:

Date:

Run Start ***NR1***QC: 21

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

MAY 04 2017

DSI 9705

A

100

Document Control

MAY 04 2017

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI9705-011 CHG001

CB ③ 17-05-04

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control